

Date: Friday, 6/23/2006 2:25:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP MOD KIT
 Job Number : 27681
 Estimate Number : 12474
 P.O. Number : N/A Part Number : DSI9340011
 This Issue : 6/23/2006 S.O. No. : N/A Drawing Number : DSI9340 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27680 Material : N/A
 Due Date : 6/30/2006 Qty: 44 Um: Each
 Written By : See comment below
 Checked & Approved By : 06-06-23 m
 Comment : Est Rev:A New Issue 06-06-23 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPDS9340-011 CHG 001

KS 06/04/23

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0 D22301 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 88.0000 Each(s)
 Mounting Lug
 Batch: B2554

4.0 D22303 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 88.0000 Each(s)
 Mounting Lug
 Batch: B26593


5.0 D2732 Rubber Extrusion



Comment: Qty.: 0.2500 f(s)/Unit Total : 11.0000 f(s)
 Rubber Cushion
 Batch: B26472

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 2/16/26

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 6/23/2006 2:25:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP MOD KIT

Job Number: 27681

Part Number: DSI9340011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 176.0000 Each(s)

Bolt

Batch: M161199

7.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 352.0000 Each(s)

Washer

Batch: M100575 195 M101369 157 mcp

8.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 176.0000 Each(s)

Nut

Batch: M19085

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP DSI 9340-011

Location: ---

PPP Rev: ---DRAFT

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



U 06-06-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

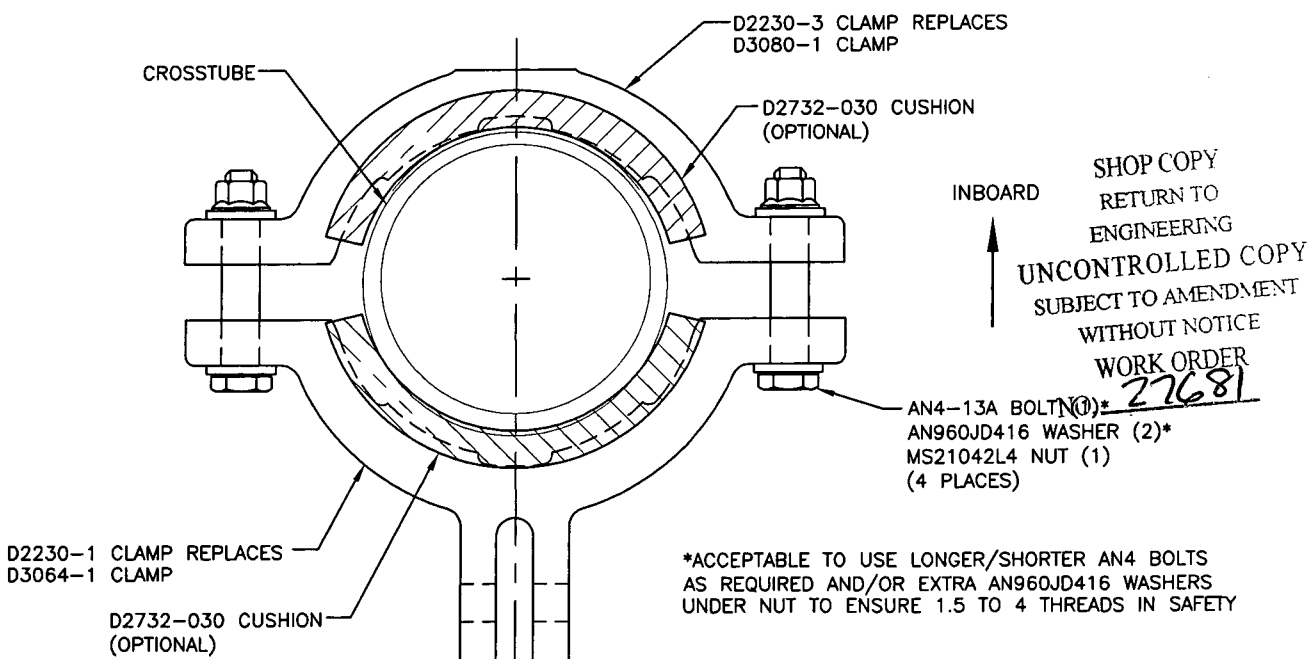
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9340	REV. A SHEET 1 OF 2
DATE 06.06.21		TITLE STEP MODIFICATION KIT	SCALE NTS
A	06.06.21	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-591 REV. E OR F
REF. CANADIAN STC: SH92-6
FAA STC: SH967NE

TO IMPROVE THE FIT OF THE D350-591-213/-214/-215/-216 STEPS, INSTALL THE D2230-1/-3 CLAMPS AS SHOWN BELOW. IN PLACE OF THE D3064-1 AND D3080-1 CLAMPS CALLED OUT ON DRAWING D350-591 REV. E OR F.

CUSTOMERS HAVE THE OPTION OF INSTALLING THE D2732-030 RUBBER CUSHIONS UNDER THE D2230-1/-3 CLAMPS TO ACCOMMODATE VARYING CROSSTUBE DIAMETERS.



FOR CUSTOMERS WITH EARLY MODEL D350-591-213/-214/-215/-216 STEPS, THE DSI 9340-011 STEP MODIFICATION KIT IS AVAILABLE

QTY	PART NUMBER	DESCRIPTION
X	DSI 9340-011	STEP MODIFICATION KIT
2	D2230-1	MOUNTING LUG
2	D2230-3	MOUNTING LUG
4	D2732-030	CUSHION
4	AN4-13A	BOLT
8	AN960JD416	WASHER
4	MS21042L4	NUT (OR MS21042-4)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 06.06.21
CERT. NO.: SH92-6
ISSUE NO.: 9/10

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DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9340	REV. A SHEET 2 OF 2
DATE 06.06.21		TITLE STEP MODIFICATION KIT	SCALE NTS

REVISED PARTS LIST FOR D350-591-213/-214/-215/-216 AT CHG 002

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> TM , Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> TM , Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> TM , Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> TM , Short Step – Low Skid, RH
1				D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
2	2	2	2	D2230-1	MOUNTING LUG
2	2	2	2	D2230-3	MOUNTING LUG
4	4	4	4	D2732-030	CUSHION
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-35A	BOLT
2	2	2	2	AN4-11A	BOLT
4	4	4	4	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
12	12	12	12	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
6	6	6	6	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27681

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 06.06.21
CERT. NO.: SH92-6
ISSUE NO.: 9/10

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